

DT 8731 -601



Dart Aerospace Ltd.
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Canada

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D2668-1

Job Sheet 192274



Part No: D2668-1

Job Qty: 4 pcs

Part Name: Saddle, LH, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/20/19

Job Tracking No:

Due Date: 4/5/19 *April 12*

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP: D 02.03.15 Added DEO 9122 NG IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	4/5/19		0.00	9.14	HAAS - 1		
							HAAS - 2		
							HAAS - 3		<i>15B2 19/03/30</i>
							HAAS - 4		
110	Conventional Mill - 1 - B4B	4 pcs	4/5/19		0.00	9.14	Conventional Mill - 1 - B4B		<i>SB2 19/03/30</i>
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs	4/5/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		



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Container No: S167907



Part: D2668-1

Job No: 192274

Serial No/Batch: S167907

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/29/19

130 QC 8	4 pcs	4/5/19	0.00 0.00	QC 2 - 57	SBL 19/03/30
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
QC 8 - 45					
QC 8 - 49					
QC 8 - 58					
QC 8 - 8	B. 19-04-12				
QC 8 - 9					
QC 8 - 68					
QC 8 - 67					
QC 8 - 1 (A)					
QC 8 - 47					
QC 8 - 40					
QC 8 - 52					
QC 8 - 23					
140 Handfinish - 1-1 Chemical-B4B	4 pcs	4/5/19	0.00 0.12	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/04/15
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 1 White Gl(A)-B4B	4 pcs	4/5/19	0.00 0.14	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BK 19-04-15.
				Powdercoat - 4 - B4B	
160 QC 3	4	4/5/19	0.00 0.00	QC 3 - 10	
				Plex 3/20/19 11:04 AM Dart.lajeunesse.marie	

	pcs				QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
						DAS 40 9-89
						APR 15 2019
170 Packaging 3-1 - Stock - B4B	4	4/5/19	0.00	0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
						APR 17 2019
180 QC 21 - SA	4	4/5/19	0.00	0.00	QC 21 - SA - 21	
	pcs				QC 21 - SA - 70	
					QC 21 - SA - 53	
						DAS 70 9-89
						APR 17 2019

Part Op 100 - Program batch number. 1-Inspect part number and batch number are programmed correctly. 3-Fixturing Inspection
 Descriptions: last completed on 19-03-30 by h.a. 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension
 Sheet 5-Machine Step No 2 of F
 110 - Machine Keyway and inspect per attached dimension sheet
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 160 - QC3- Inspect Part Finish
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	4 pcs (1 ea)	100-HAAS 4 Axis	5133675 x 4
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-001	4	31	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD				Work Order: 192274	
Description: 206 Saddle, Inboard, Left side				Part Number: D2668-1	
Inspection Dwg: D2668 Rev: D DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.120	.120	.121	.121	
B	0.100	0.140		.116	.116	.116	.116	
C	1.125	1.145		1.135	1.135	1.135	1.135	
D	0.615	0.685		.645	.650	.650	.650	
E	0.240	0.260		.252	.251	.252	.253	
F	1.313	1.343		1.324	1.323	1.323	1.323	
G	0.210	0.220		.220	.220	.226	.220	
H	0.100	0.180		.132	.134	.132	.132	
I	2.470	2.510		2.495	2.495	2.500	2.495	
J	1.565	1.585		1.575	1.575	1.575	1.575	
K	0.235	0.240		.239	.239	.238	.238	
L	0.100	0.120		.115	.115	.115	.115	
M	0.990	1.010		1.000	1.000	1.00	1.000	
N	0.510	0.515		.510	.510	.510	.510	
O	5.990	6.010		5.996	5.996	5.996	5.996	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.312	0.318		.312	.312	.312	.312	
S	0.315	0.322		.316	.316	.316	.316	
T	1.995	2.005		2.000	2.00	2.000	2.000	
U	1.357	1.367		1.362	1.362	1.362	1.362	
V	0.787	0.807		.795	.795	.795	.795	
W	1.040	1.060		1.048	1.048	1.048	1.048	
X	1.674	1.684		1.679	1.679	1.679	1.679	
Y	0.256	0.262		.257	.257	.257	.257	
Z	0.912	0.932		.919	.919	.919	.919	
AA	0.490	0.510		.496	.496	.496	.496	
AB	0.178	0.198		.188	.188	.188	.188	
AC								
AD								
AE								

DAS Accept/Reject

Measured by: 57	Date: 19/03/30
Audited by: 9-89	Date: 19-04-12
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Revised dimensions R and Y	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					